

# Work Order ID 65153

Thursday, January 06, 2011 2:56:22 PM

Page 1

Item ID: D3912-3

Accept

Revision ID:

Item Name: Eyebolt Block

Start Date: 1/6/2011 Start Qty: 12.00

Required Date: 1/14/2011 Req'd Qty: 12.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3912

B

100

Cut blanks as per folio

0.00



Bandsaw

Memo

0.00

Jeaspa Bandsaw

CUT BLANK 2.50" LONG

SL 11/01/11

(16)

110

0.00



HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

MACHINE AS PER FOLIO FA870 AND DWG

FOLIO REV: AA

DWG REV: B

SL 11/01/12

(12)

DEBURR

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

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Date:

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SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

SL 11/01/12

QC

Memo

0.00

12 10

Quality Control

130

QC8- Inspect parts - second check

0.00

SL 11/01/12

QC

Memo

0.00

12 10

Quality Control

160

Identify as per dwg &amp; Stock Location: ST 096

0.00

SL 11/01/13

Packaging

Memo

0.00

12

Packaging

W/O:		WORK ORDER CHANGES					
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Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/01/13

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**NOTE:** Date & initial all entries

# Picklist Print

Thursday, January 06, 2011 2:56:26 PM

Page 1

Work Order ID: 65153

Parent Item: D3912-3

Parent Item Name: Eyebolt Block



Start Date: 1/6/2011

Required Date: 1/14/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP REV:A NEW ISSUE 09-11-25 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M303B1.000X1.000

Purchased

No

100

f

9.9660

0.208

2.627368



303 BAR 1" X 1"



2.65 1/10/11

Location

Loc Qty

Loc Code

MAT

8.737

115555

8.737

MAT53

1.22896

113719

1.22896

2.65

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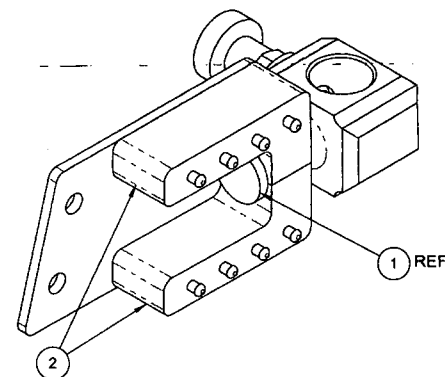
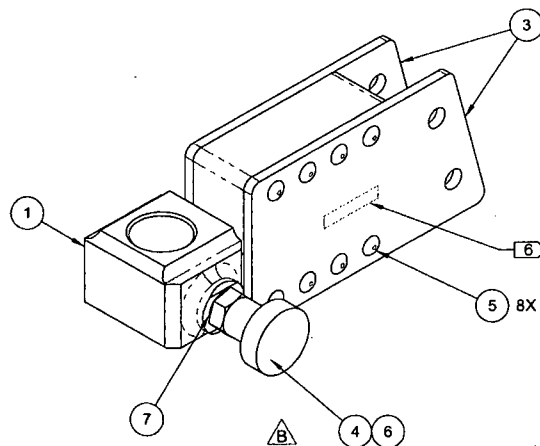
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**NOTE:** Date & initial all entries

ITEM	QTY	P/N	DESCRIPTION
	X	D3912-041	EYEBOLT RECEIVER ASSY
1	1	D3912-1	EYEBOLT
2	2	D3912-3	EYEBOLT BLOCK
3	2	D3912-5	EYEBOLT PLATE
4	1	D3801-1	SPRING PLUNGER
5	8	MS20615-4M20	RIVET
6	1	MS21209-F615	HELICAL
7	1	NAS1149F0332P	WASHER

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 45153  
BS11-01-4



SUPPLEMENTAL ISO VIEW  
(EYEBOLT PLATE REMOVED  
TO SHOW INTERIOR FEATURES)

# **D3912-041 EYEBOLT RECEIVER ASSY**

## NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N D3912-041 USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT -041: 1.58 lbs

RELEASED  
2010-07-16

B	D3801-1 WAS D3810-1 SPRING PLUNGER; D4028-041 RMV; MS21209-F615 WAS MS21209-C610 HELICAL; (1) WASHER NAS1149C0683R ADDED; BOSS ADDED TO D3912-1.	JPH	10.06.28
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>ALS</i>		
DRAWN	<i>JS</i>		
CHECKED	<i>JS</i>		
MFG. APPR.	<i>JS</i>		
APPROVED	<i>JS</i>		
DE APPR.	<i>JS</i>		
DATE	10.06.28		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3912** REV. B  
SHEET 1 OF 3  
TITLE **EYEBOLT RECEIVER ASSY** SCALE NTS

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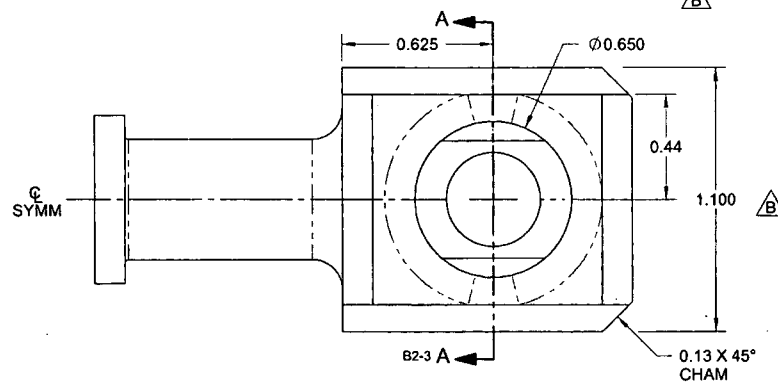
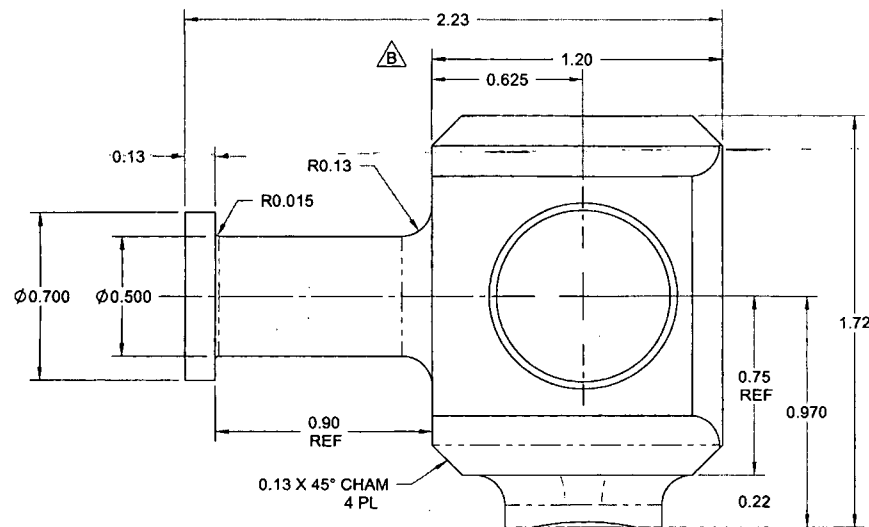
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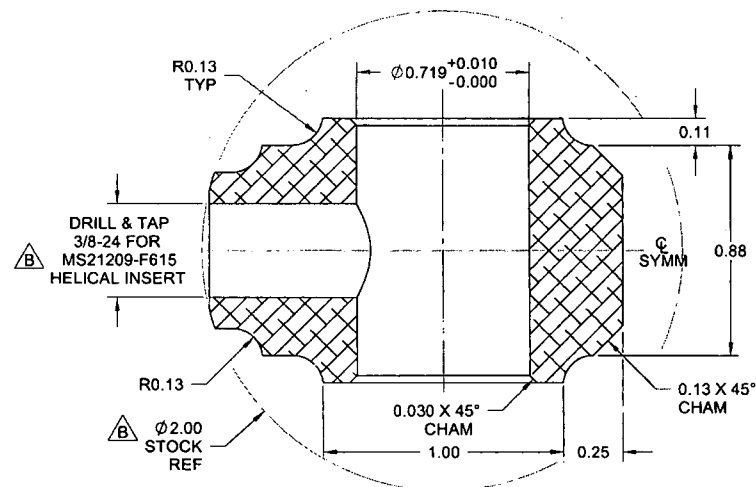
**NOTE:** Date & initial all entries



# **D3912-1 EYEBOLT**

## **NOTES:**

- 1) MATERIAL: 303/304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276 OR ASTM A582  
REF DART SPEC M303R OR M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ID AT ASSEMBLY
- 7) WEIGHT: 0.45 lbs



## **SECTION A-A B6-3**

**RELEASED**  
2010-07-16

DESIGN	ALS	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3912	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		EYEBOLT RECEIVER ASSY	NTS
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Technical drawing of a plate with a grid of holes and a slanted section. The drawing includes the following dimensions and features:

- Overall width: 3.15
- Overall height: 1.500 (+0.020, -0.000)
- Top edge thickness: 0.38
- Top edge radius: R0.13 TYP
- Grid of holes: 4 columns, 2 rows. Pitch: 1.500, 0.500 PITCH.
- Top hole diameter:  $\varnothing 0.129$  8 PL
- Bottom hole diameter:  $\varnothing 0.257$  2 PL
- Slanted section: 105° REF, 0.375, 0.517, 1.000
- Bottom edge thickness: 0.125 REF
- Bottom edge radius: R0.13 TYP

DESIGN		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA			
DRAWN		DRAWING NO. <b>D3912</b>	REV. B		
CHECKED			SHEET 3 OF 3		
MFG. APPR.				SCALE	
APPROVED				<b>EYEBOLT REVERSE ASSY</b>	NTS
DE APPR.					
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